

Work Order ID 65254

January 10, 2011 10:34:40 AM



Page 1

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 1/10/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EL 11-1-17

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

7m, 1/10/10

6X

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulavio

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65254



Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
-----	--	------	--	--	--	--	--	--	--

	Large Fab	<i>M 108436</i>							
--	-----------	-----------------	--	--	--	--	--	--	--

Large Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Large Fab	1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 2- grind weld flush at the end of tube only								
-----------	---	--	--	--	--	--	--	--	--

EL *11-1-17* *(X6)*

140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--

--	--	--	--	--	--	--	--	--	--

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

BE *11-1-17* *(60)*

150	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

--	--	--	--	--	--	--	--	--	--

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

8/10/17

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65254

January 10, 2011 10:34:41 AM



Page 3

Item ID: D3572-041

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Setup Start



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Item Name: Guide Assembly

Start Date: 1/10/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00

=> M

11/01/17

6

0



HandFinish

Memo

0.00

Hand Finishing

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:15

OVEN TEMPERATURE: 320°

FINISH TIME: 8:45

6

11-01-19

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M

11/01/09

26

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 65254

January 10, 2011 10:34:41 AM



Page 4

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Start Date: 1/10/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

11/01/19 6

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/19 mf
11-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

January 10, 2011 10:34:40 AM

Page 1

Work Order ID: 65254

Parent Item: D3572-041

Parent Item Name: Guide Assembly


Start Date: 1/10/11

Required Date: 1/19/11

Start Qty: 6.00


Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
 IPP rev B revB dwg EC
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3572-3  Guide		Manufactured	No			130	Each	27.0000	4	24			

Location	Loc Qty	Loc Code
ST244	7	
62215	7	
ST245A	20	
64444	20	

65088 x 19.

D3572-5  Bracket		Manufactured	No			130	Each	11.0000	1	6			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST072	6	
59405	6	
WA	5	
54119	5	

65100 x 6

M6061T6T1.000W.188  6061T6 RD TUBE 1.00 X .188W		Purchased	No			110	f	53.5164	2.34	14.77895			
--	--	-----------	----	--	--	-----	---	---------	------	----------	--	--	--

Location	Loc Qty	Loc Code
MAT	36.24126	
115868 ✓	36.24126	
MAT016	17.275108	
114089	17.275108	

11/01/10
 14-77895

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

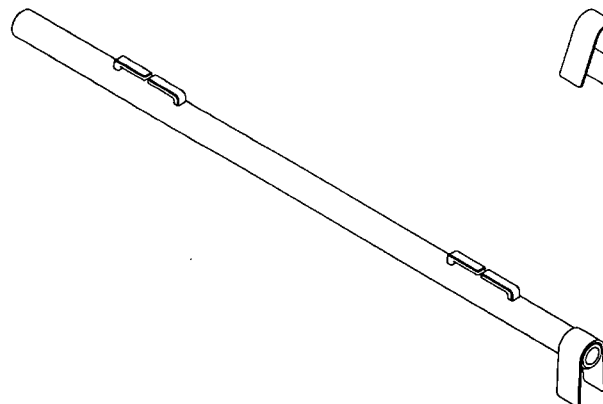
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

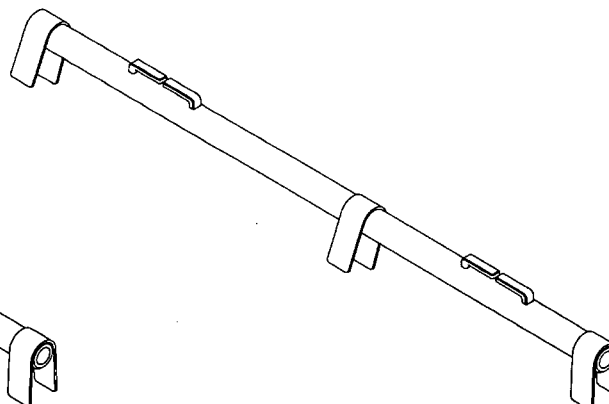
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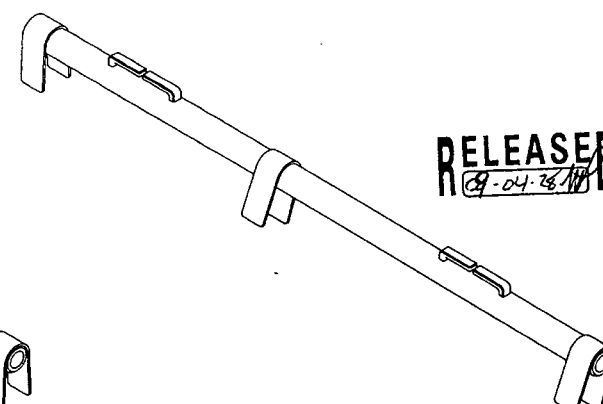
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. D
MFG. APPR.	LE	D3572	SHEET 1 OF 4
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	GUIDE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ? Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

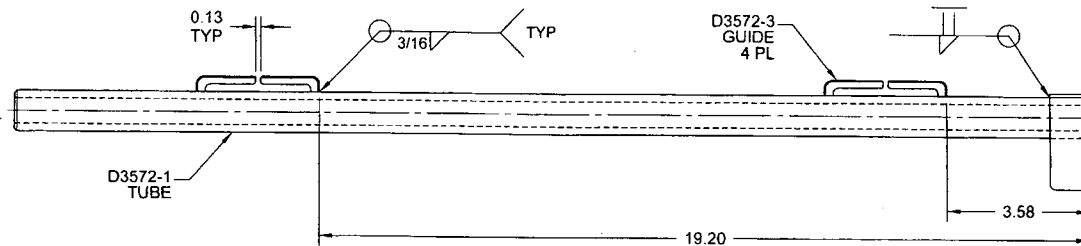
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4

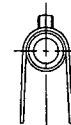
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2

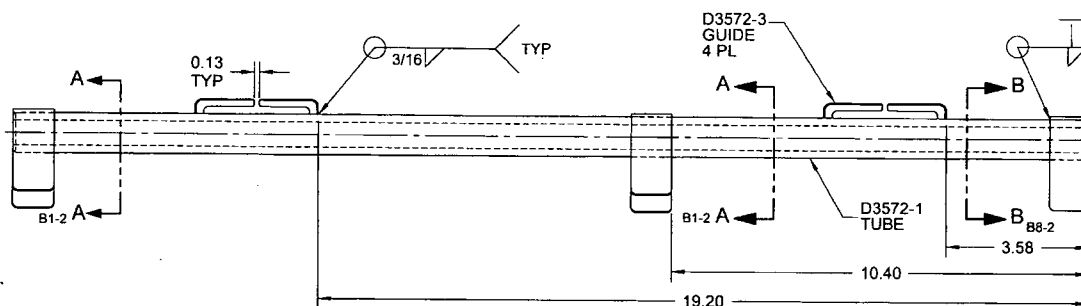
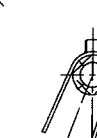
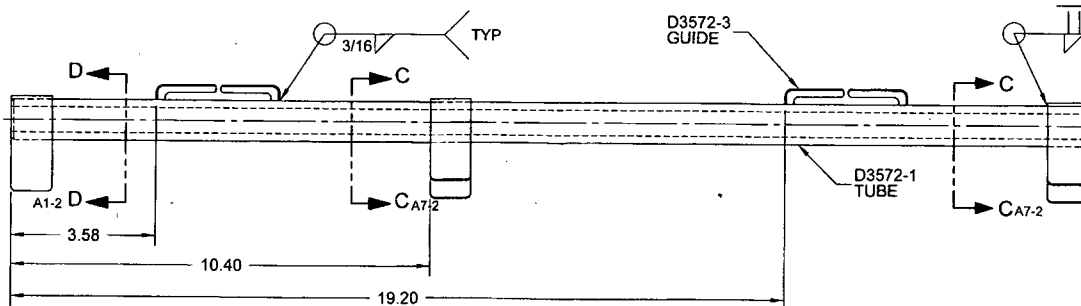
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**D3572-041 GUIDE ASSEMBLY**

65254



D3572-5 BRACKET

**D3572-043 GUIDE ASSEMBLY**D3572-5 BRACKET
TYP**SECTION B-B** C2-2**SECTION A-A** C7-2
(2 PL) C4-2**D3572-044 GUIDE ASSEMBLY****SECTION C-C** A2-2
A5-2**SECTION D-D** A7-2

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
09.04.18D3572-5 BRACKET
TYP

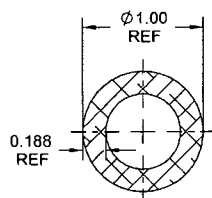
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

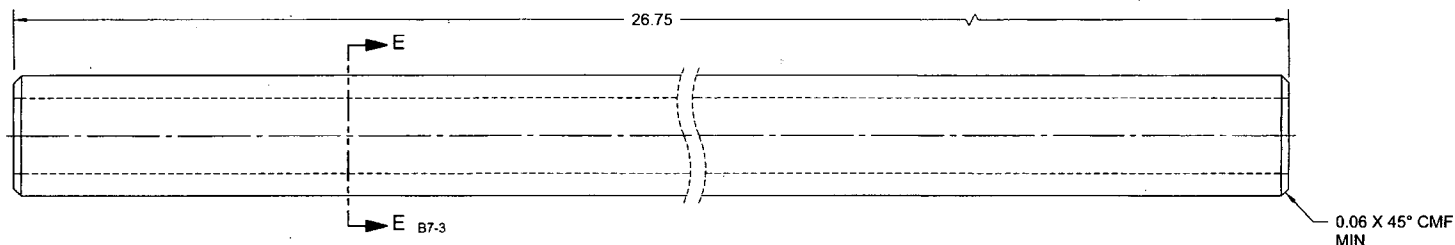
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION E-E C5-3



D3572-1 TUBE

W10' 65254
C21110110

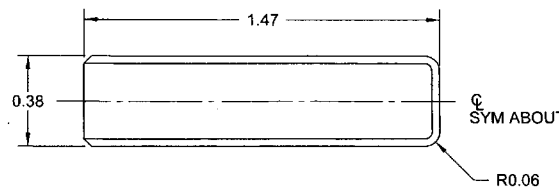
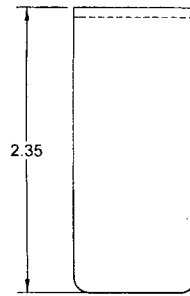
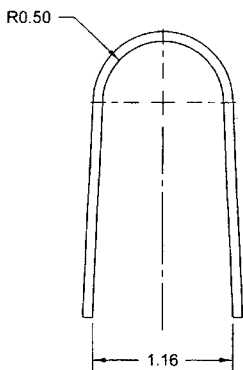
RELEASED
09/04/17

D3572-1 NOTES:

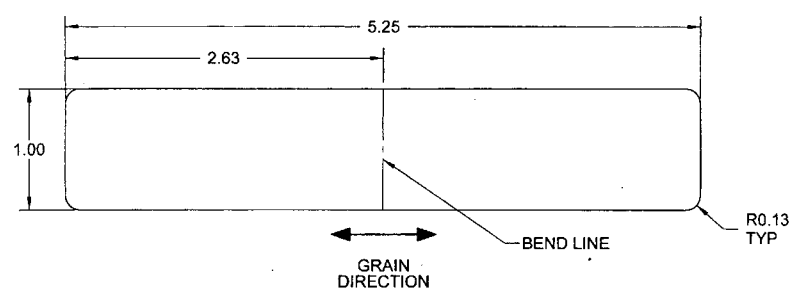
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
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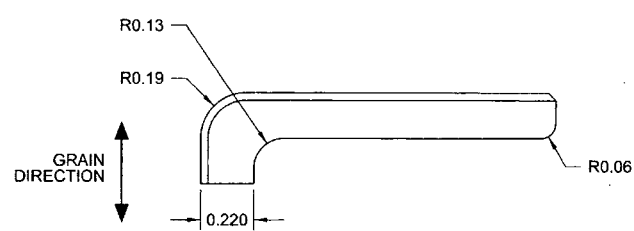
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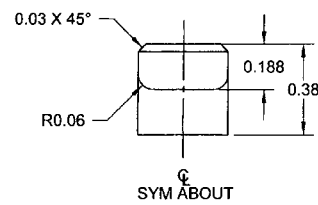
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



W10.65254
C21110110

RELEASED

- D3572-3 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160) REF DART SPEC M6061T6B
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

- D3572-5 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M60601T6S.080
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.04 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG APPR.		D3572	SHEET 4 OF 4
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8 7 6 5 4 3 2 1